Page 1

December 8, 2009 11:27:00 AM Accept Item ID: D3786-1 Setup Start **Revision ID:** Stop Item Name: Sleeve **Start Qty: 20.00 Start Date:** 08/12/2009 Cust Item ID: **Required Date: 16/12/2009** Req'd Qty: 20.00 Customer: Reference: Run Start Date Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Set Up/ Reject Draw Plan Sequence ID/ Operation Draw Accept Reject Insp. Qty Qty Work Center ID Description Number Rev. Code Number Stamp **Run Hours** Draw Nbr **Revision Nbr** D3786 Rev A 0.00 100 DOOSAN LATHE 0.00 Doosan 1- Turn as per Folio FA747 Rev: N/A & Dwg D3786 Rev: A \quad \text{D2-Deburr} \text{D} \quad \text{OP} \land \text{D2/Q8} Doosan Lathe per dwg D3786 09/12/28 110 QC2- Inspect parts off machine FAI/FAIB 0.00 QC Memo Quality Control 120 QC8- Inspect parts - second check 0.00 20 0.00 Memo Quality Control

Dart Aerospa	ice Ltd
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W/O:			W	ORK ORDER CHANG	SES						
DATE	STEP	PRO	OCEDURE CH	ANGE		By Date Q			Qty Approval Chief Eng / Prod Mgr		
									•		
				•							
Part No	:	PAR #:	Fault Cat	tegory:	_ NCR	: Yes I	No DQ	<b>A:</b>	Date:	-	
	R	esolution:	Dispositi	ion:	QA:	N/C Clo	sed:		Date: _	· 	
NCR:			WORK ORI	DER NON-CONFORM	ANCE	(NCR)	)				
DATE	STEP	Description of NC Corrective Action			Section B Veri			fication Approval		Approval	
DAIL	SIEP	Section A	Initial Chief Eng	Action Description  Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector	
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#### Work Order ID 54376



Page 2

December 8, 2009 11:27:00 AM

**Required Date: 16/12/2009** 

Item ID: **Revision ID:**  D3786-1

Accept

Setup Start



Stop

Item Name: **Start Date:** 

Sleeve 08/12/2009

QC:

Start Qty: 20.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Rev.

Run

Start



Req'd Qty: 20.00

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

HandFinish

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/ **Run Hours** 

Draw Number

Plan Draw Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Hand Finishing

140

QC

Quality Control

OC3- Inspect Part Finish

Memo

0.00

0.00

0.00

Mpolodos

150

Packaging Packaging

Identify as per dwg & Stock Location: 249

0.00

16-1-5

Memo

0.00

# **Dart Aerospace Ltd**

	Jopass												
W/O:		44-44	WORK ORDER CHANGES										
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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				- 74 - 14									
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	<b>A</b> :	Date: _					
	R	esolution:	Disposition	_ QA: N/C (	QA: N/C Closed: Date:								
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)							
		Description of NC	Pagarintian of NC Corrective Acti		Section B			Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date			Chief Eng	QC Inspector				
								5					
							***						
l	1												

### Work Order ID 54376



Page 3

December 8, 2009 11:27:00 AM

Item ID: Revision ID: D3786-1

Accept



Setup Start



Stop

Item Name: **Start Date:** 

Sleeve 08/12/2009

Start Qty: 20.00 Reg'd Oty: 20.00

Cust Item ID: Customer:

Reference:

	_	
A	nnrovals	•

Process Plan:

Date:

Tooling:

Date:

Start Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

**Required Date: 16/12/2009** 

160

QC

Description

Operation

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours Draw Number

Draw Rev.

Plan Code Qty

Reject Accept Qty

Reject Number

Insp. Stamp

Memo

0.00

0.00

Quality Control

h 12.01.05

## Dart Aerospace Ltd

		—- <del></del>									
W/O:			WO	RK ORDER CHANG	ES	., .,					
DATE	STEP	PRO	PROCEDURE CHANGE				ty Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No: PAR #:		PAR #:	Fault Categ	ory:	NCR: Yes No DQA: Date:						
Resolution:			Disposition	:	_ QA: N/C Clo	QA: N/C Closed: Date:					
NCR:			WORK ORDE	ER NON-CONFORMA	ANCE (NCR	)					
DATE	STEP	Description of NC		Corrective Action Section		Verification	on Approval	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector			
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1											
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### **Picklist Print**

December 8, 2009 11:27:06 AM

Work Order ID: 54376

Parent Item:

Comments:

D3786-1

Parent Item Name: Sleeve



**Start Date:** 08/12/2009

**Required Date: 16/12/2009** 

Page 1

**Start Qty: 20.00** 

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prima Item Locat	•	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased	No		110	f	58.3994	3.5095			

6061T6 RD TUBE 1.00 x .065w

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

58.3994082

2.18

110778 111029

56.2194082

3.506 SL 09/12/28

# **Dart Aerospace Ltd**

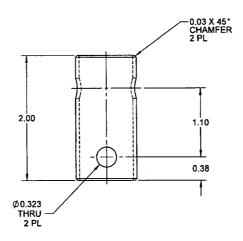
W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No <b>DQ</b>	<b>A</b> :	Date:	
Resolution:			Disposit	QA	: N/C CI	Date: _				
NCR:			WORK OR	DER NON-CONF	ORMANCE	(NCR	)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Desc						Approval Chief Eng	Approval QC Inspector
		And the same of th	Chief Eng	Chief Eng		Date				
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DART AEROSPACE LTD	Work Order:	54374
Description: Sleeve	Part Number:	D3786-1
Inspection Dwg: 03786 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

	FIRST A	AKTIOLE III	31 2011			•		
	X	First Artic	le	Proto	type			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Metho		Con	nments
Ø0.985	+0.000/-0.010	. 950						
0.058	+/-0.010	.05%						
0.03 x 45°	+/-0.030 x +/-0.5°	.03 × 45°						
2.00	+/-0.030	2.00	1				·	
1.10	+/-0.030	1-10					<u>.                                    </u>	
0.38	+/-0.030	.380	<b>/</b>					
Ø0.323	+0.006/-0.001	.323	~					
-								
<u>, 7</u>								
	\							
Measured by:	JL	Audited by:	21/2	,	Proto	type Ap	proval:	N/A
Date:	09/12/28	Date:	59/12/	28/			Date:	N/A
Rev Date	Change		/ /			Revise		Approved
A 08.07.25	New Issue					KJ/DD	- cX\}-	

Ø0.985<sup>+0.000</sup> 0.058 REF



SHOPE

RETU ...

ENGINE:

UNCONTROL

SUBJECT TO .

WITHOUT LINE

WORY NO\_54376 Pl04-12-8

#### **D3786-1 SLEEVE**

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000 X 0.065 WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-220/8 OR QQ-A-225/8 (REF. DART SPEC. M8061T6T1.000W.065)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 ibs

Α	NEW IS	SUE	HS	08.06.04			
REV.		i	DESCRIPTION	BY	DATE		
DESIGN	4	HS	DART AEROSPACE LTD				
DRAW	1	HS	HAWKESBURY, ONTARIO, CANADA				
CHECK	ED.	84/	DRAWING NO. RE				
MFG. A	PPR.	120	D3786		SHEET 1 OF 1		
APPRO	VED	1087	TITLE , SC.				
DE APP	PR.	4	SLEEVE				
DATE	08.0	6.04	COPYRIGHT © 2018 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONSISTION THAT IT IS NOT TO BE USED FOR ANY PURPORT OR CONFIDENCE TO LOW ORMS FOR THE PERSON WITHOUT				

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